FIG.1

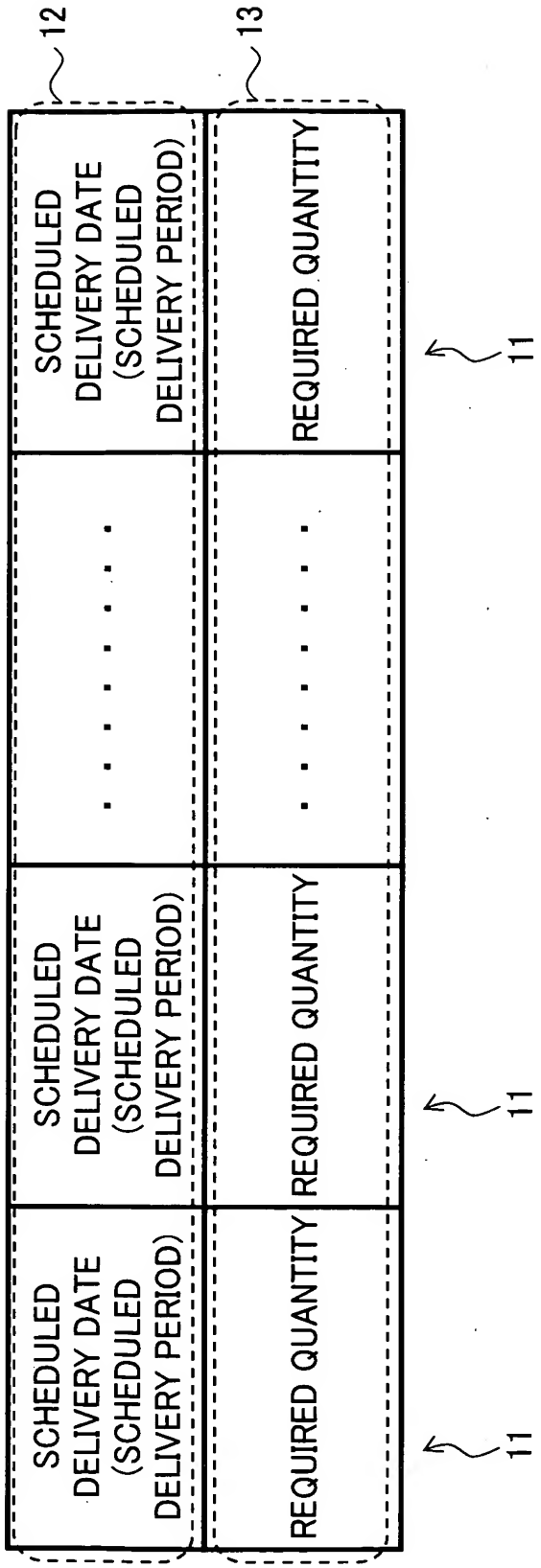

10
12
13
SCHEDULED DELIVERY DATE (SCHEDULED DELIVERY PERIOD)
REQUIRED QUANTITY
11
11
11

FIG.2

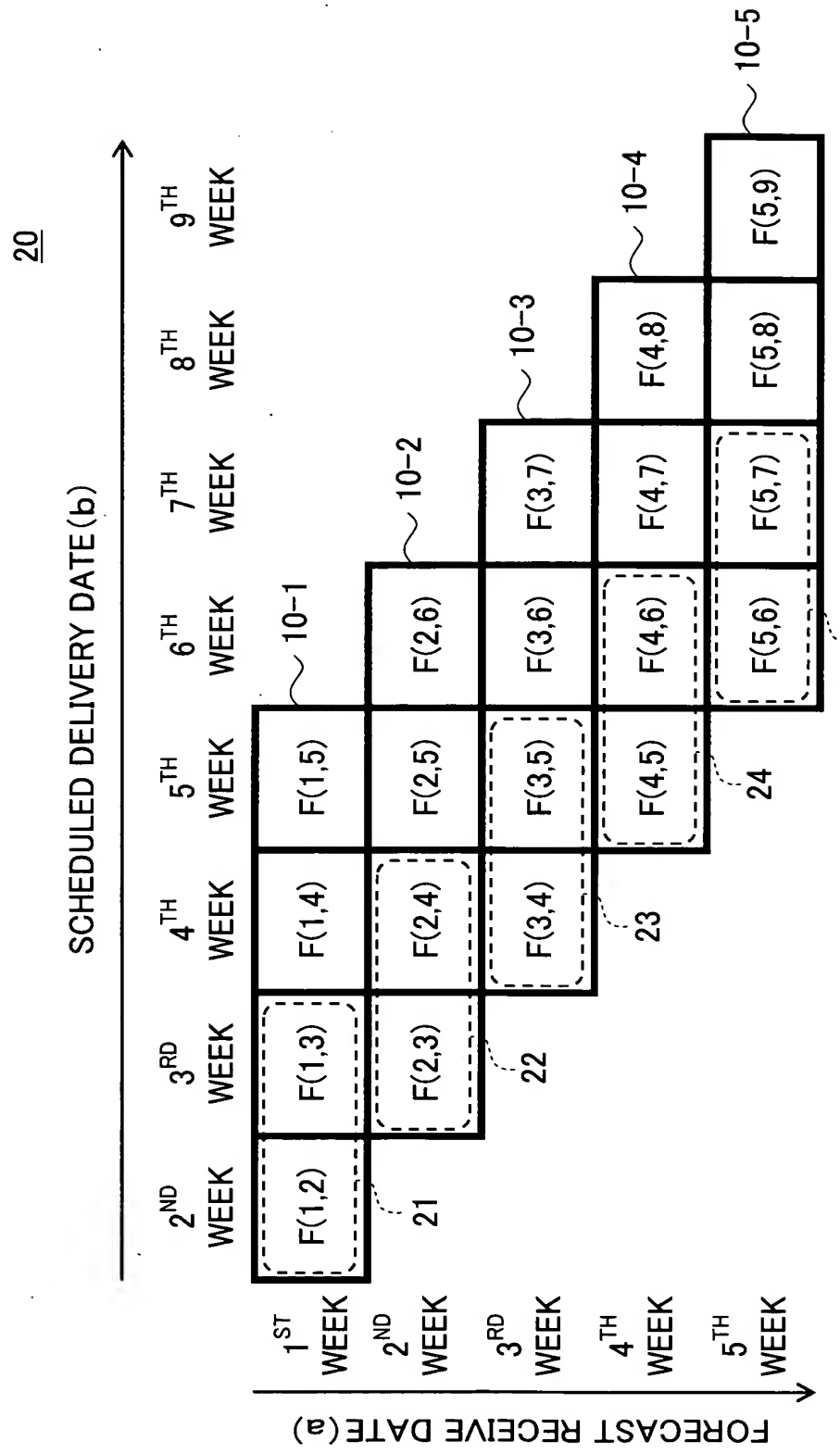

20
SCHEDULED DELIVERY DATE (b)
2ND WEEK
3RD WEEK
4TH WEEK
5TH WEEK
6TH WEEK
7TH WEEK
8TH WEEK
9TH WEEK
FORECAST RECEIVE DATE (a)
1ST WEEK
2ND WEEK
3RD WEEK
4TH WEEK
5TH WEEK
F(1,2)
F(1,3)
F(1,4)
F(1,5)
F(2,3)
F(2,4)
F(2,5)
F(2,6)
F(3,4)
F(3,5)
F(3,6)
F(3,7)
F(4,5)
F(4,6)
F(4,7)
F(4,8)
F(5,6)
F(5,7)
F(5,8)
F(5,9)
10-1
10-2
10-3
10-4
10-5
21
22
23
24
25

FIG.3

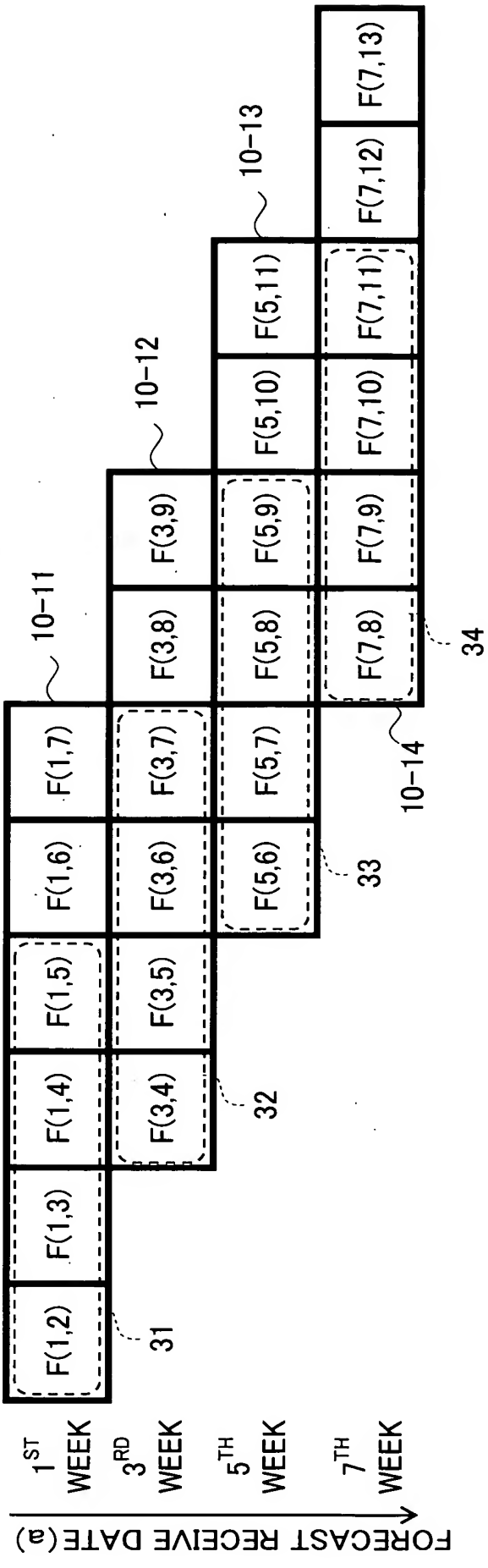

30
SCHEDULED DELIVERY DATE (b)
2ND WEEK
3RD WEEK
4TH WEEK
5TH WEEK
6TH WEEK
7TH WEEK
8TH WEEK
9TH WEEK
10TH WEEK
11TH WEEK
12TH WEEK
13TH WEEK
F(1,2)
F(1,3)
F(1,4)
F(1,5)
F(1,6)
F(1,7)
F(3,4)
F(3,5)
F(3,6)
F(3,7)
F(3,8)
F(3,9)
F(5,6)
F(5,7)
F(5,8)
F(5,9)
F(5,10)
F(5,11)
F(7,8)
F(7,9)
F(7,10)
F(7,11)
F(7,12)
F(7,13)
31
32
33
34
10-11
10-12
10-13
10-14
1ST WEEK
3RD WEEK
5TH WEEK
7TH WEEK
FORECAST RECEIVE DATE (a)

FIG.4

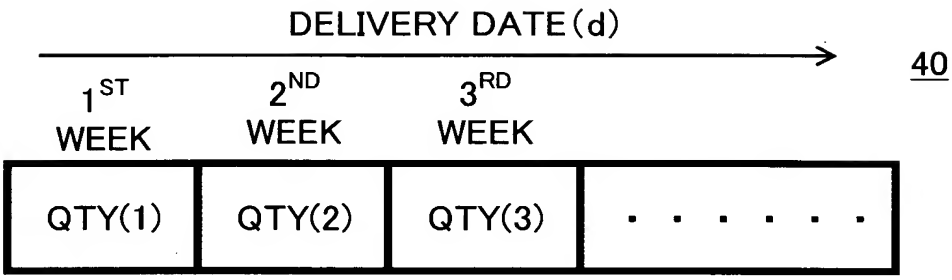


FIG.5

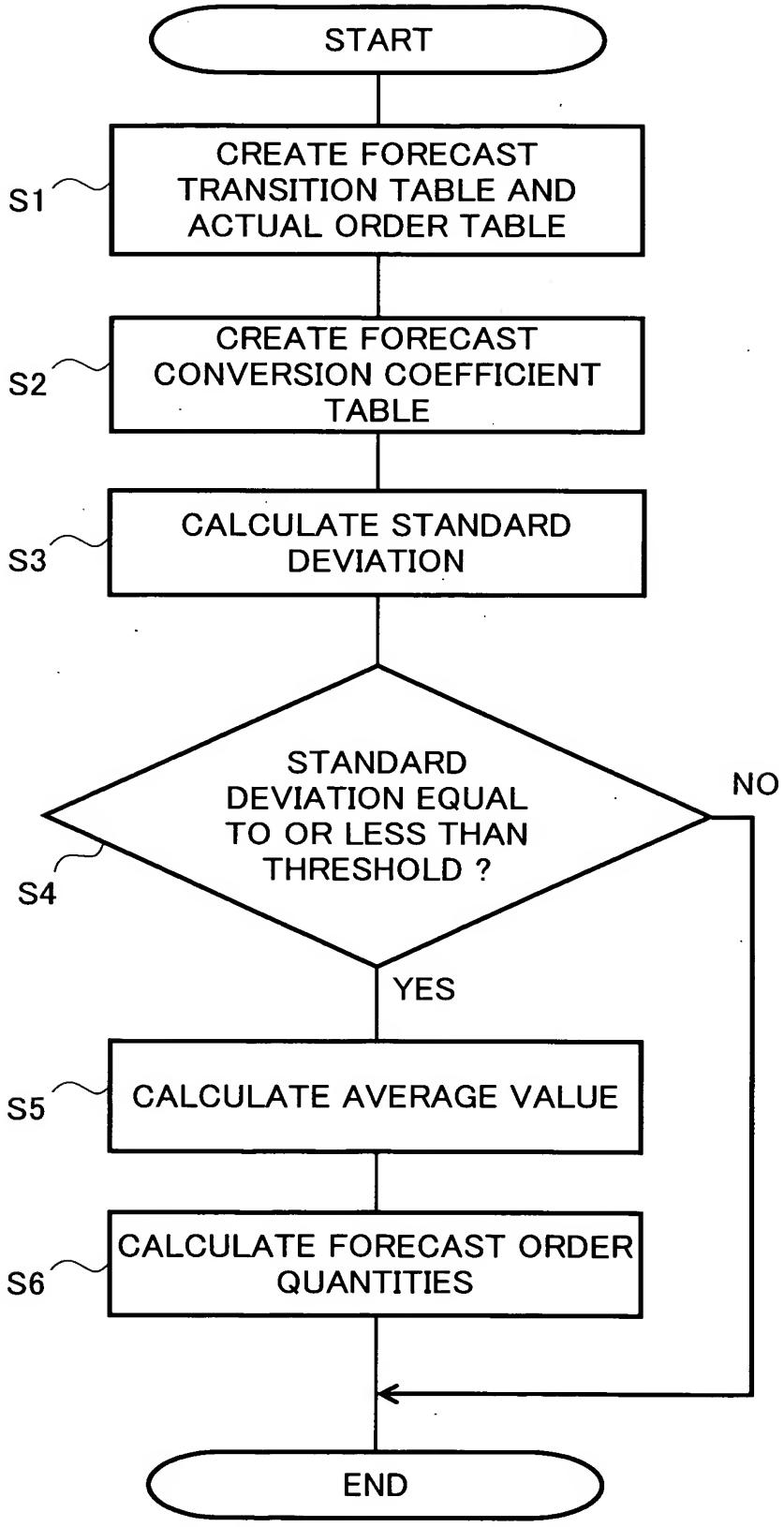
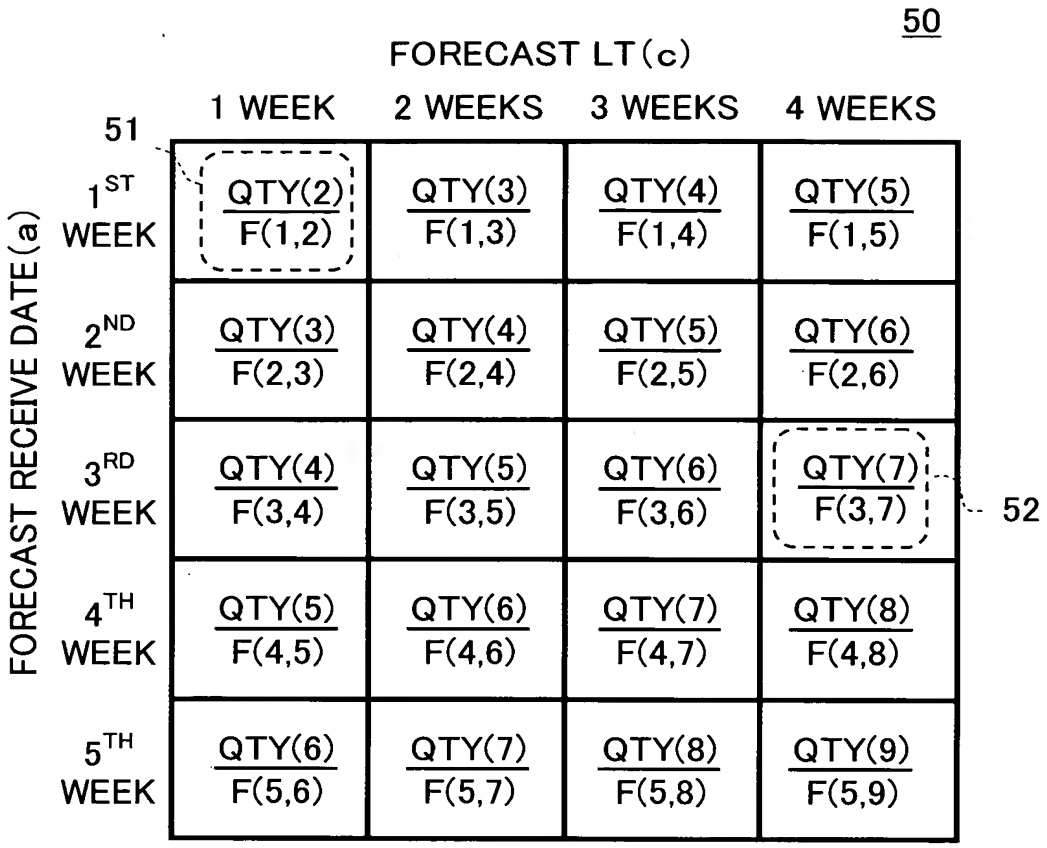
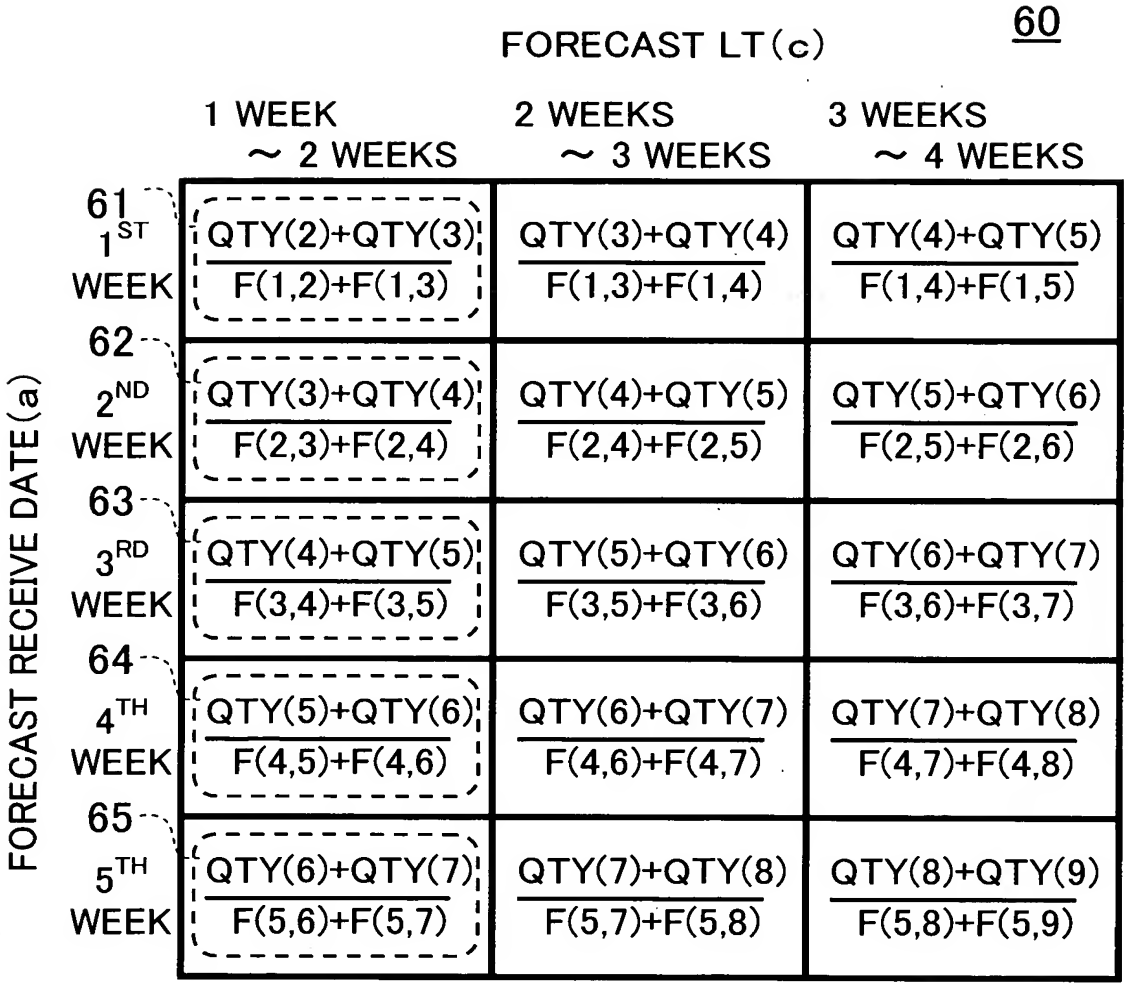

START
S1
CREATE FORECAST TRANSITION TABLE AND ACTUAL ORDER TABLE
S2
CREATE FORECAST CONVERSION COEFFICIENT TABLE
S3
CALCULATE STANDARD DEVIATION
S4
STANDARD DEVIATION EQUAL TO OR LESS THAN THRESHOLD ?
NO
YES
S5
CALCULATE AVERAGE VALUE
S6
CALCULATE FORECAST ORDER QUANTITIES
END

FIG.6


50
FORECAST LT (c)
1 WEEK
2 WEEKS
3 WEEKS
4 WEEKS
51
FORECAST RECEIVE DATE (a)
1ST WEEK
2ND WEEK
3RD WEEK
4TH WEEK
5TH WEEK
QTY(2) F(1,2)
QTY(3) F(1,3)
QTY(4) F(1,4)
QTY(5) F(1,5)
QTY(3) F(2,3)
QTY(4) F(2,4)
QTY(5) F(2,5)
QTY(6) F(2,6)
QTY(4) F(3,4)
QTY(5) F(3,5)
QTY(6) F(3,6)
QTY(7) F(3,7)
52
QTY(5) F(4,5)
QTY(6) F(4,6)
QTY(7) F(4,7)
QTY(8) F(4,8)
QTY(6) F(5,6)
QTY(7) F(5,7)
QTY(8) F(5,8)
QTY(9) F(5,9)

# FIG.7


60
FORECAST LT(c)
1 WEEK ～ 2 WEEKS
2 WEEKS ～ 3 WEEKS
3 WEEKS ～ 4 WEEKS
FORECAST RECEIVE DATE(a)
61
1ST WEEK
62
2ND WEEK
63
3RD WEEK
64
4TH WEEK
65
5TH WEEK
QTY(2)+QTY(3) / F(1,2)+F(1,3)
QTY(3)+QTY(4) / F(1,3)+F(1,4)
QTY(4)+QTY(5) / F(1,4)+F(1,5)
QTY(3)+QTY(4) / F(2,3)+F(2,4)
QTY(4)+QTY(5) / F(2,4)+F(2,5)
QTY(5)+QTY(6) / F(2,5)+F(2,6)
QTY(4)+QTY(5) / F(3,4)+F(3,5)
QTY(5)+QTY(6) / F(3,5)+F(3,6)
QTY(6)+QTY(7) / F(3,6)+F(3,7)
QTY(5)+QTY(6) / F(4,5)+F(4,6)
QTY(6)+QTY(7) / F(4,6)+F(4,7)
QTY(7)+QTY(8) / F(4,7)+F(4,8)
QTY(6)+QTY(7) / F(5,6)+F(5,7)
QTY(7)+QTY(8) / F(5,7)+F(5,8)
QTY(8)+QTY(9) / F(5,8)+F(5,9)

# FIG.8

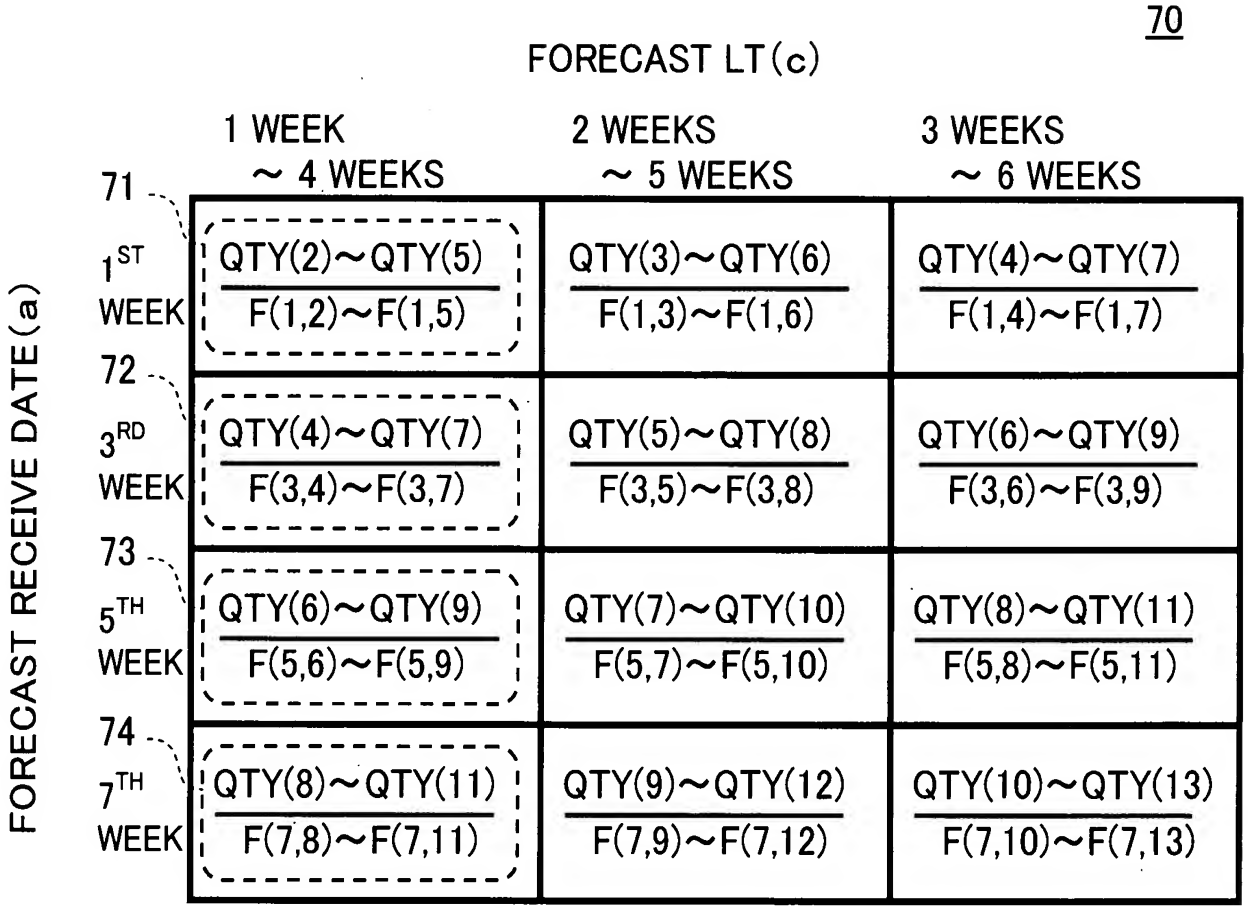



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FIG.9

80

| | FORECAST LT(c) | | | |
|---|---|---|---|---|
| | 1 WEEK | 2 WEEKS | 3 WEEKS | 4 WEEKS |
| STANDARD DEVIATION | s(1) | s(2) | s(3) | s(4) |

FIG.10

90

| | FORECAST LT(c) | | |
|---|---|---|---|
| | 1 WEEK ～ 2 WEEKS | 2 WEEKS ～ 3 WEEKS | 3 WEEKS ～ 4 WEEKS |
| STANDARD DEVIATION | s(1-2) | s(2-3) | s(3-4) |

FIG.11

100

| | FORECAST LT(c) | | |
|---|---|---|---|
| | 1 WEEK ～ 4 WEEKS | 2 WEEKS ～ 5 WEEKS | 3 WEEKS ～ 6 WEEKS |
| STANDARD DEVIATION | s(1-4) | s(2-5) | s(3-6) |

FIG.12

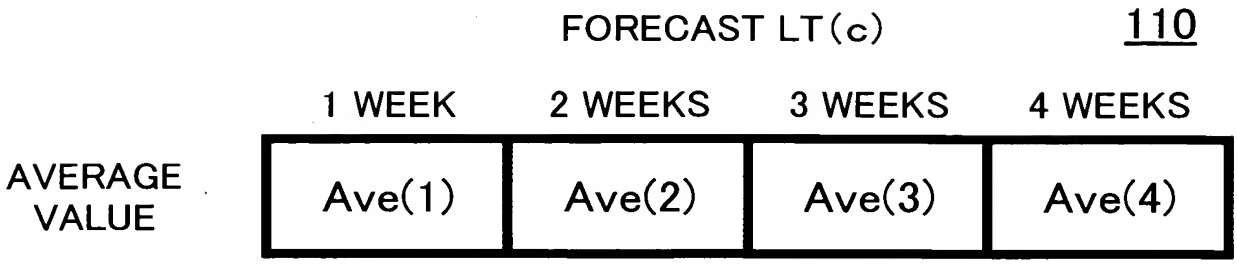



FIG.13

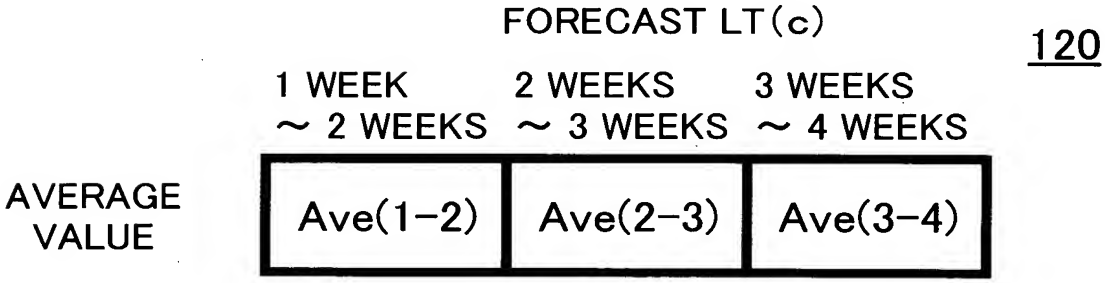



FIG.14

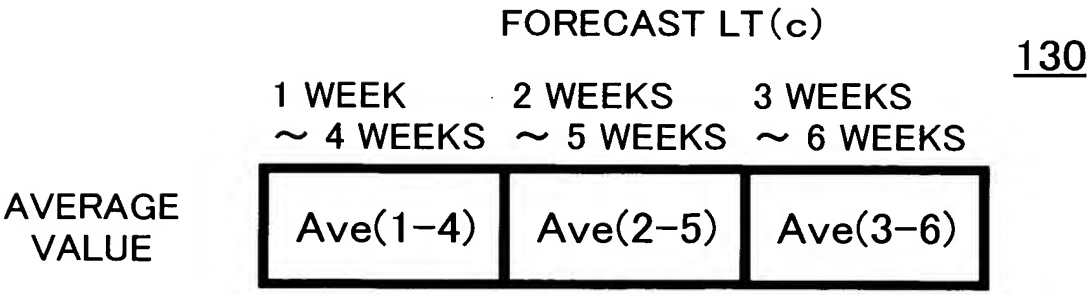


FIG.15

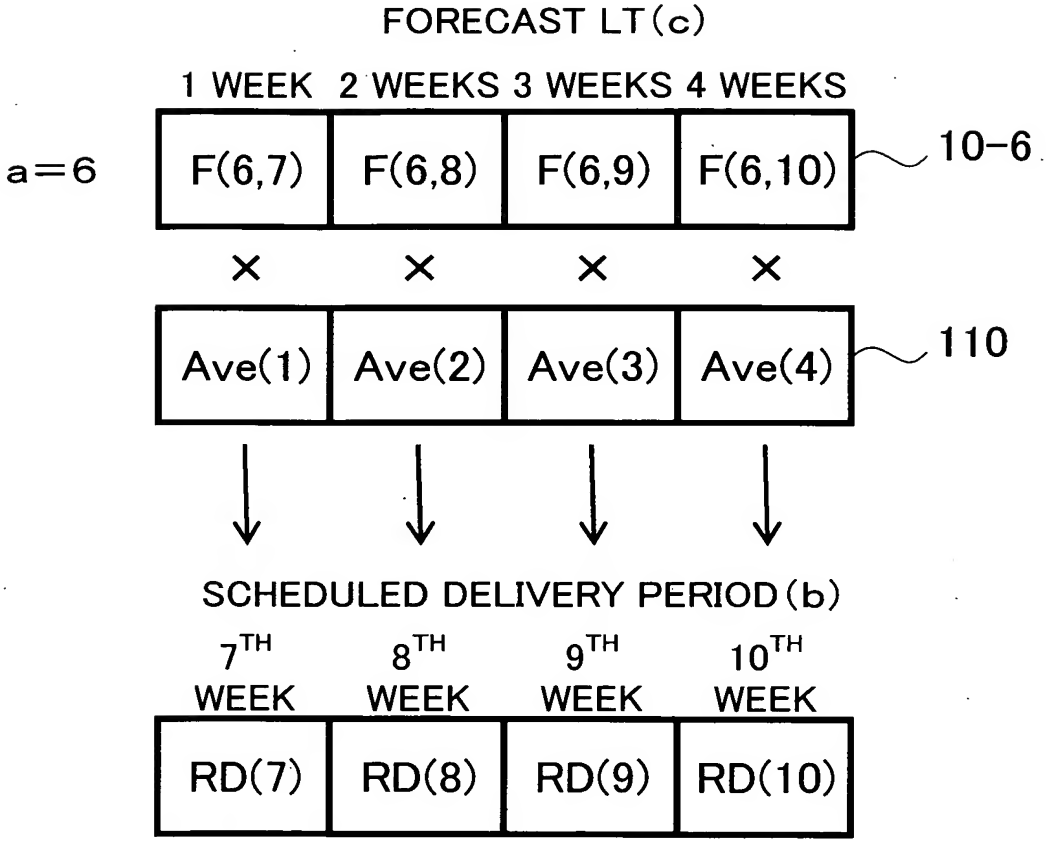

FORECAST LT(c)
1 WEEK
2 WEEKS
3 WEEKS
4 WEEKS
a=6
F(6,7)
F(6,8)
F(6,9)
F(6,10)
10-6
×
×
×
×
Ave(1)
Ave(2)
Ave(3)
Ave(4)
110
SCHEDULED DELIVERY PERIOD(b)
7TH WEEK
8TH WEEK
9TH WEEK
10TH WEEK
RD(7)
RD(8)
RD(9)
RD(10)

FIG.16

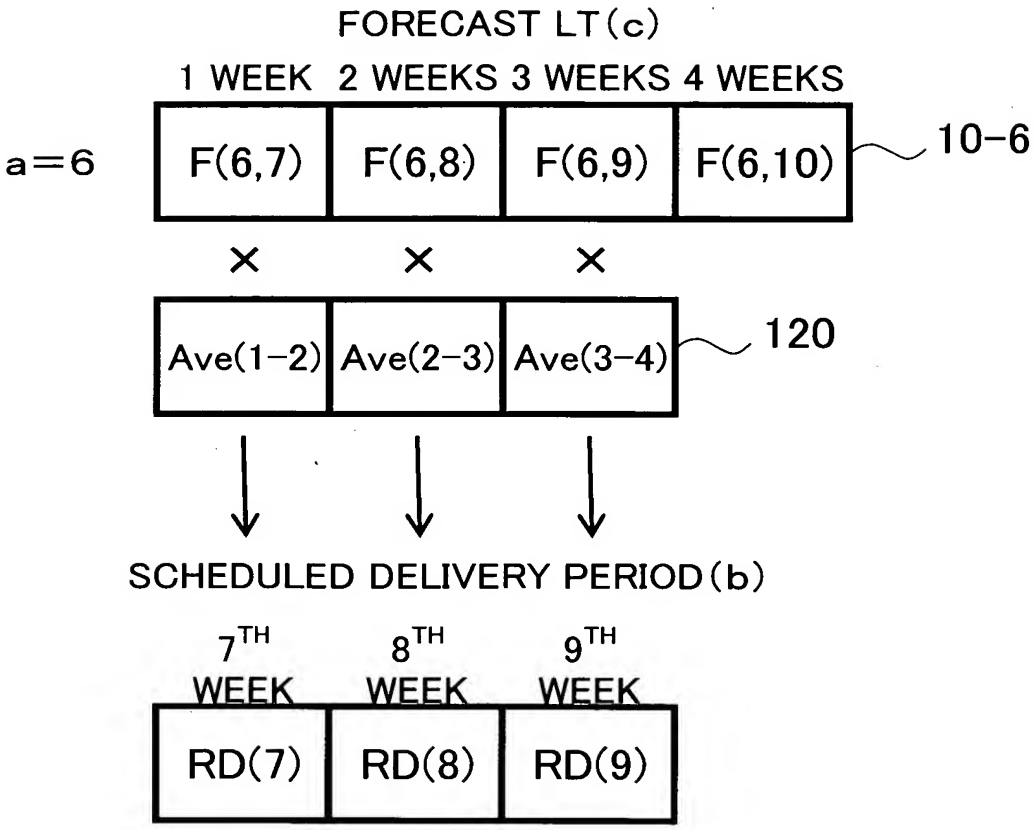

FORECAST LT(c)
1 WEEK
2 WEEKS
3 WEEKS
4 WEEKS
a=6
F(6,7)
F(6,8)
F(6,9)
F(6,10)
10-6
×
×
×
Ave(1-2)
Ave(2-3)
Ave(3-4)
120
SCHEDULED DELIVERY PERIOD(b)
7TH WEEK
8TH WEEK
9TH WEEK
RD(7)
RD(8)
RD(9)

FIG.17

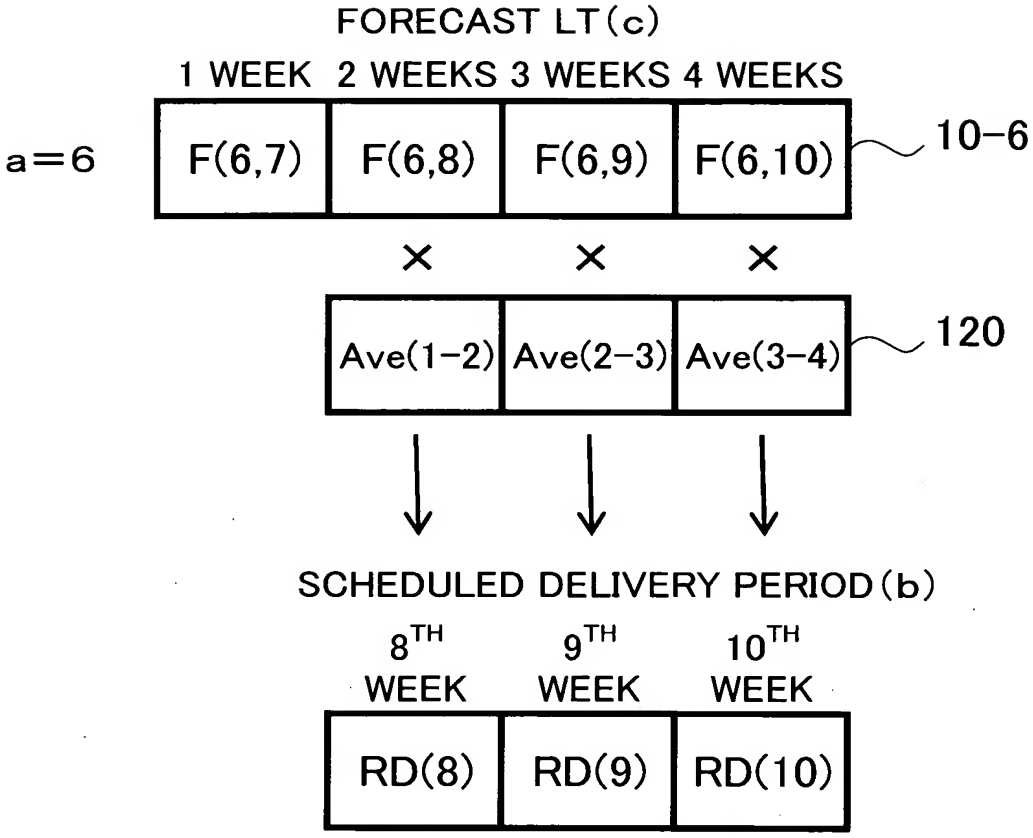

FORECAST LT(c)
1 WEEK
2 WEEKS
3 WEEKS
4 WEEKS
a=6
F(6,7)
F(6,8)
F(6,9)
F(6,10)
10-6
×
×
×
Ave(1-2)
Ave(2-3)
Ave(3-4)
120
SCHEDULED DELIVERY PERIOD(b)
8TH WEEK
9TH WEEK
10TH WEEK
RD(8)
RD(9)
RD(10)

FIG.18

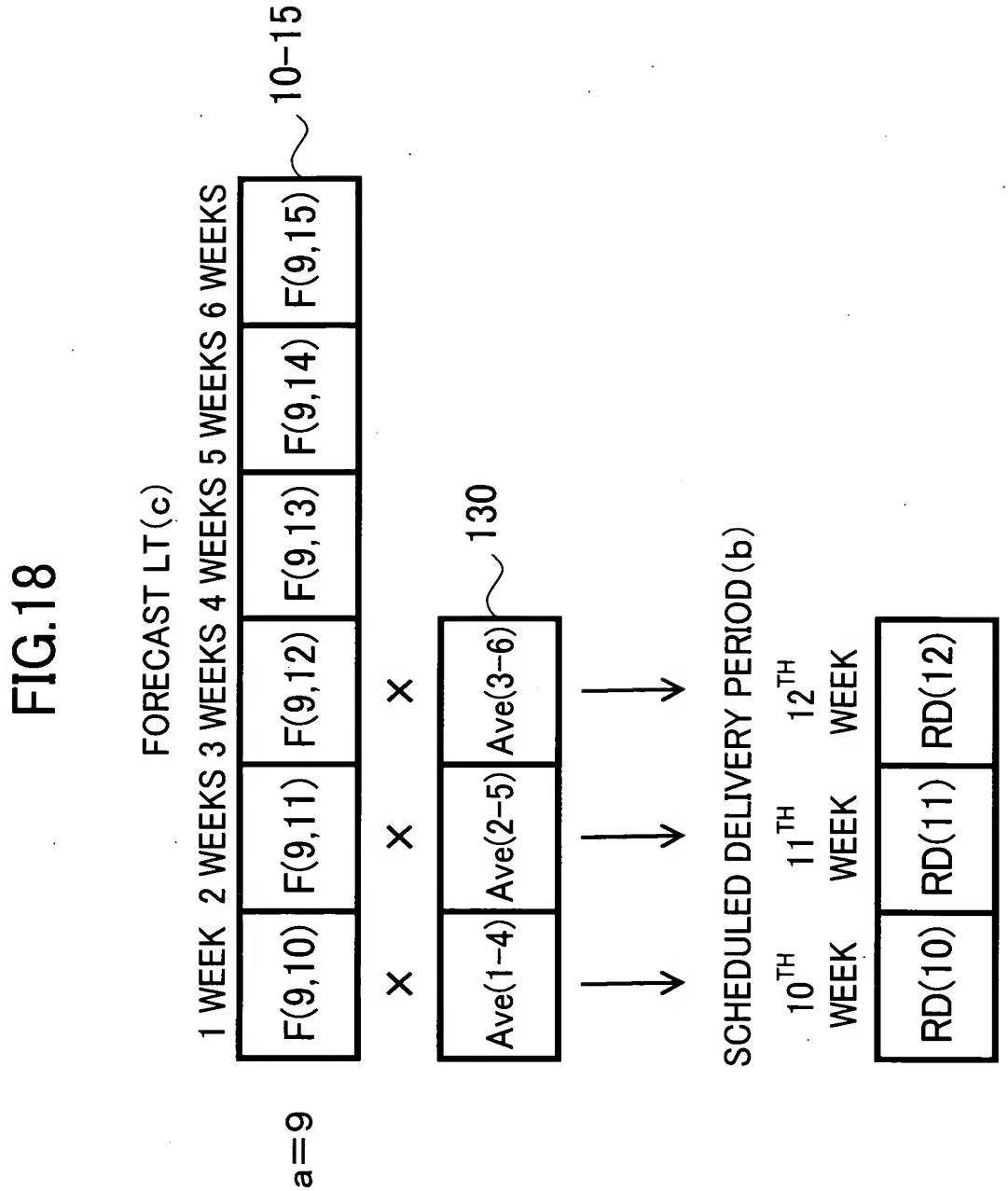

FORECAST LT(c)
1 WEEK
2 WEEKS
3 WEEKS
4 WEEKS
5 WEEKS
6 WEEKS
10-15
a=9
F(9,10)
F(9,11)
F(9,12)
F(9,13)
F(9,14)
F(9,15)
Ave(1-4)
Ave(2-5)
Ave(3-6)
130
SCHEDULED DELIVERY PERIOD(b)
10TH WEEK
11TH WEEK
12TH WEEK
RD(10)
RD(11)
RD(12)

FIG.19

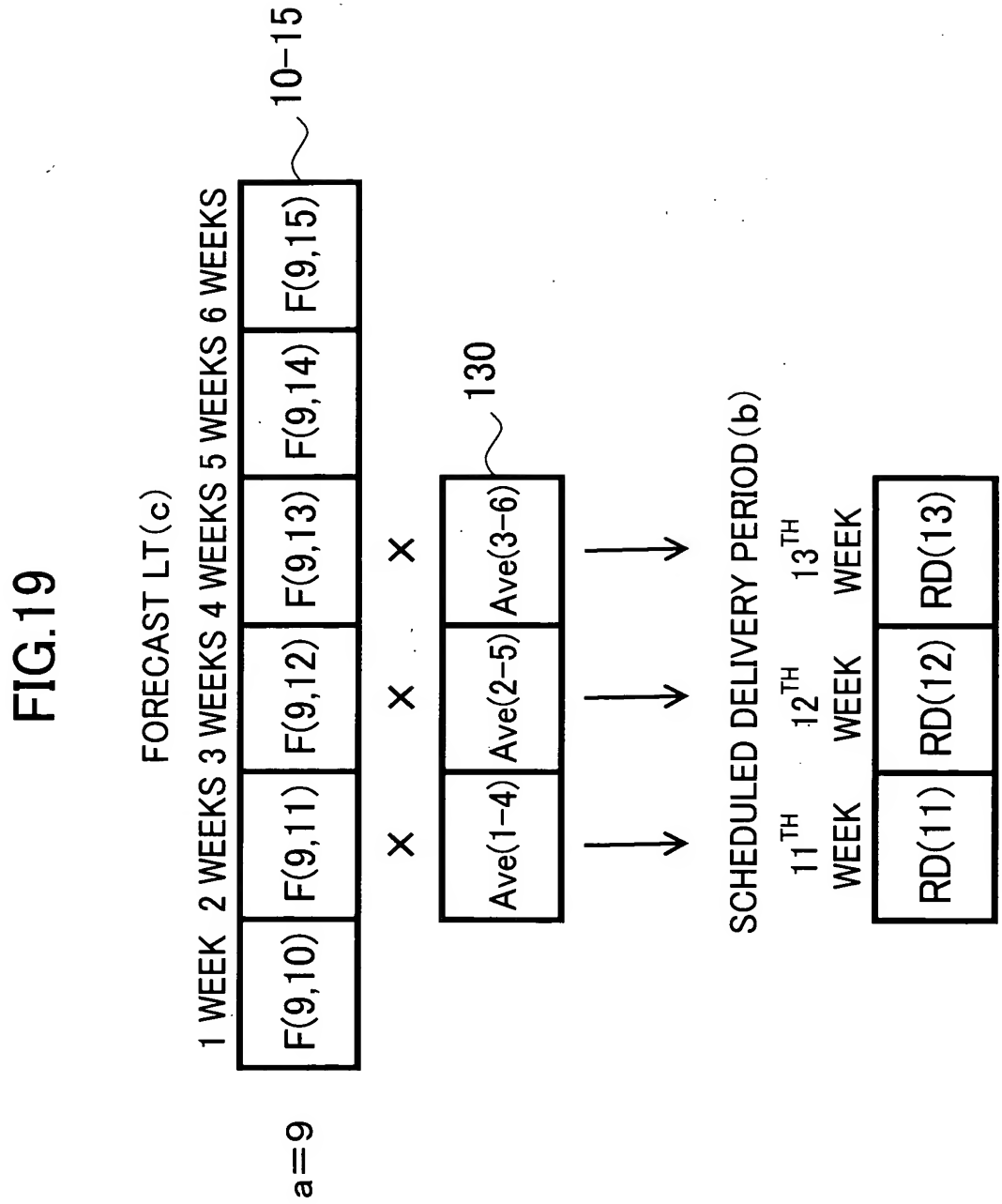

FORECAST LT(c)
1 WEEK
2 WEEKS
3 WEEKS
4 WEEKS
5 WEEKS
6 WEEKS
10-15
a=9
F(9,10)
F(9,11)
F(9,12)
F(9,13)
F(9,14)
F(9,15)
×
×
×
130
Ave(1-4)
Ave(2-5)
Ave(3-6)
SCHEDULED DELIVERY PERIOD(b)
11TH WEEK
12TH WEEK
13TH WEEK
RD(11)
RD(12)
RD(13)

FIG.20

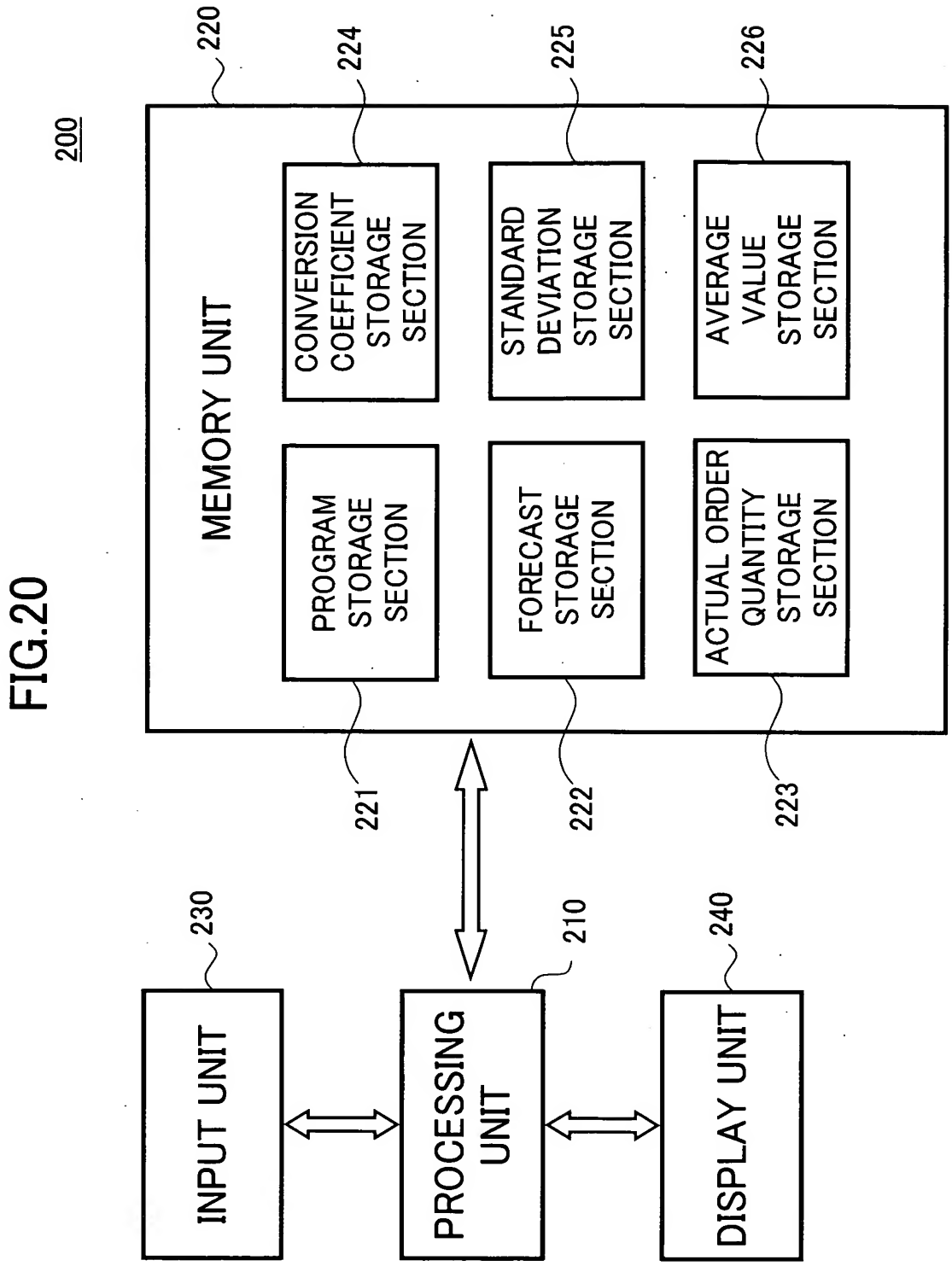

200
220
MEMORY UNIT
224
CONVERSION COEFFICIENT STORAGE SECTION
225
STANDARD DEVIATION STORAGE SECTION
226
AVERAGE VALUE STORAGE SECTION
PROGRAM STORAGE SECTION
FORECAST STORAGE SECTION
ACTUAL ORDER QUANTITY STORAGE SECTION
221
222
223
230
INPUT UNIT
210
PROCESSING UNIT
240
DISPLAY UNIT

FIG.21

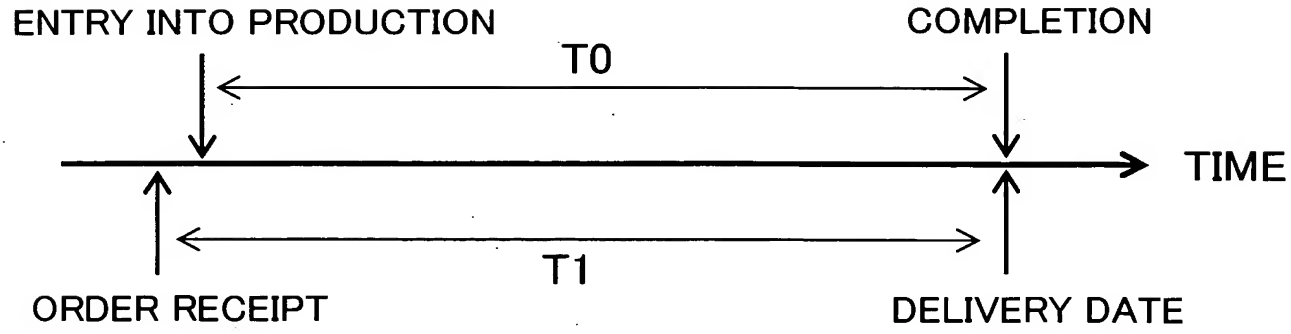
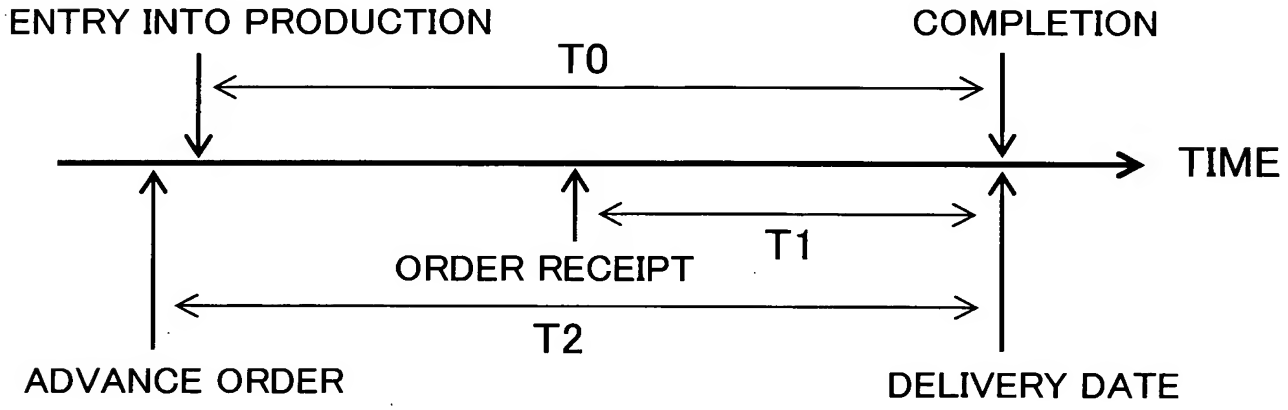



FIG.22



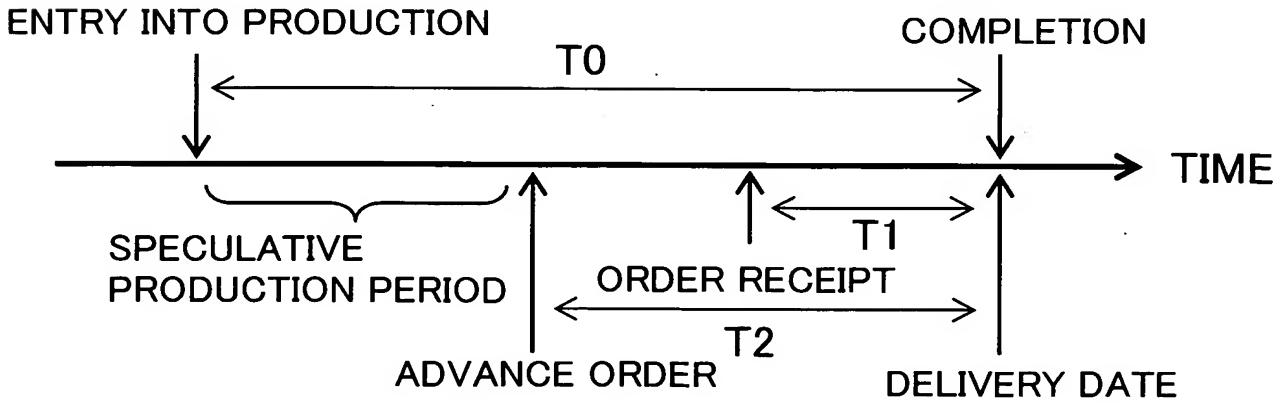


FIG.23